










Date: Wednesday, 11/03/2009 12:58:36 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	: MOUNTING LUG
<b>Job Number</b>	: 46427		
<b>Estimate Number</b>	: 10255		
<b>P.O. Number</b>	:	<b>Part Number</b>	: D22301
<b>This Issue</b>	: 11/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b>	: D2230 REV F
<b>Prsht Rev.</b>	: NC	<b>Project Number</b>	: N/A
<b>First Issue</b>	: / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b>	: F
<b>Previous Run</b>	: 45302	<b>Material</b>	:
<b>Written By</b>	:	<b>Due Date</b>	: 31/03/2009 <b>Qty:</b> 200 <b>Um:</b> Each
<b>Checked &amp; Approved By</b>	: <u>JUD 09.03.11</u>		
<b>Comment</b>	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		
<b>Additional Product</b>			
Job Number: 			
<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>	
1.0	D2423	Lug Extrusion	
			
<b>Comment:</b> Qty.: 0.0717 f(s)/Unit. Total : 14.3430 f(s) <i>45 parts = 44529 = 3.231</i> Lug Extrusion D2423 Extrusion Batch: <i>43722 x 11-113 = 155 parts</i> <i>JP 09/03/12</i>			
2.0	BAND SAW	BAND SAW	
			
<b>Comment:</b> BAND SAW Cut D2423 extrusion to 0.82" Batch: <i>JP 09/03/12</i>			
3.0	D22301P	LUG	
			
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s) <i>JP 09-03-24</i> LUG			
4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
			
<b>Comment:</b> HAAS CNC VERTICAL MACHINING #1 1-Machine per folio D2230-1 (Check for crack while loading into the machine.) 2-Tumble and deburr rough edges after tumbling <div style="text-align: right;"> <i>DJP/J-F. 09/03/14</i> <span style="border: 1px solid black; border-radius: 50%; padding: 5px; margin-left: 20px;">203</span> </div>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 11/03/2009 12:58:36 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 46427

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*DT/J.F. 09/03/14 (203)*

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*J.L. 09/03/18*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*UMP/BR*

*09/03/19*

*(1203)*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*04-03-23*

*(1203)*

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: *11:20*  
OVEN TEMPERATURE: *320°*  
FINISH TIME: *11:50*

*UMP/BR*

*09/03/23*

*(1203)*

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*FL 09/03/23*

*(203)*

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST476*

*SS 09/03/24 (203)*

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/03/24*

Job Completion



*MF 09-03-24*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

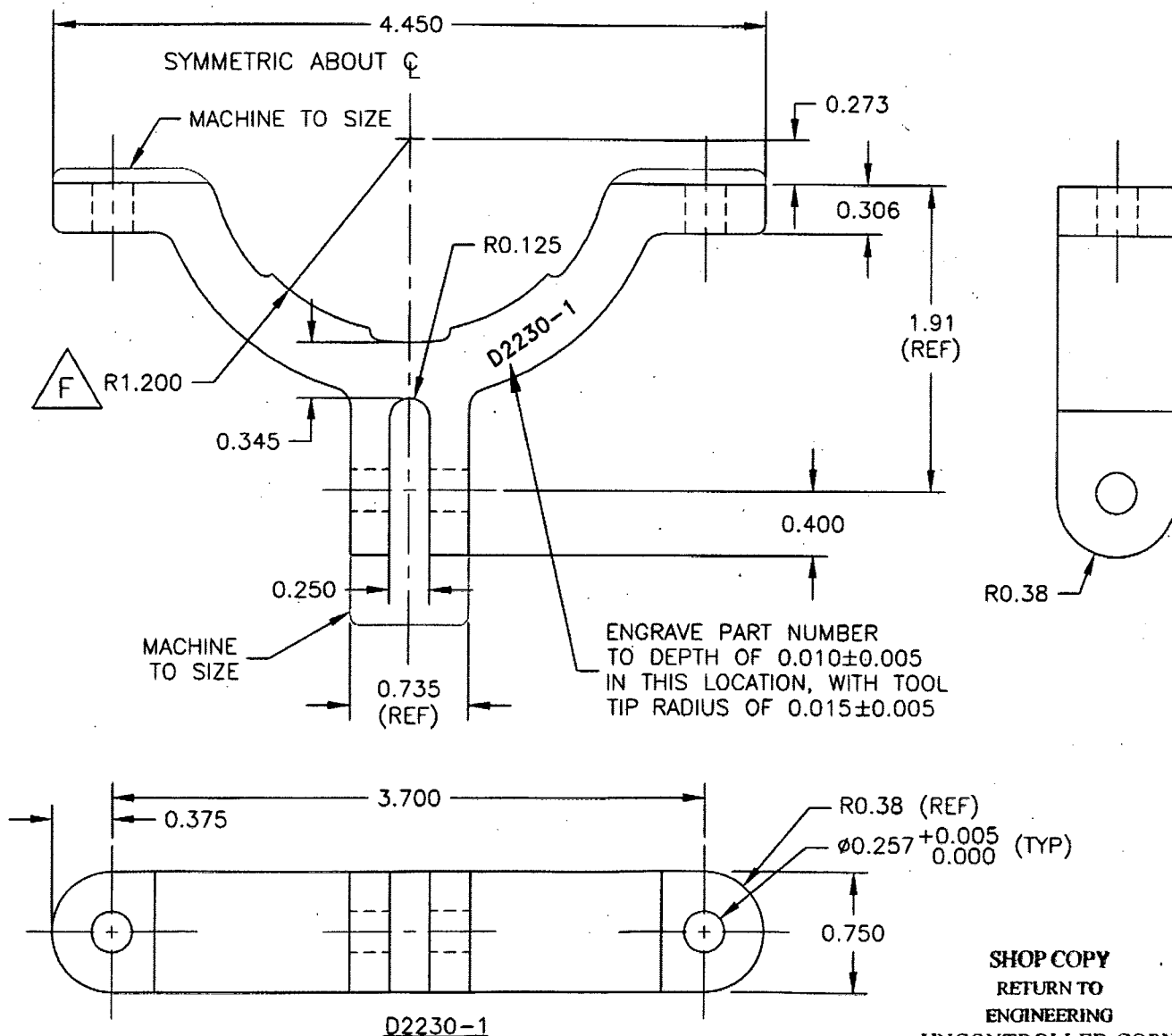
**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

RELEASED  
99.12.21 DS



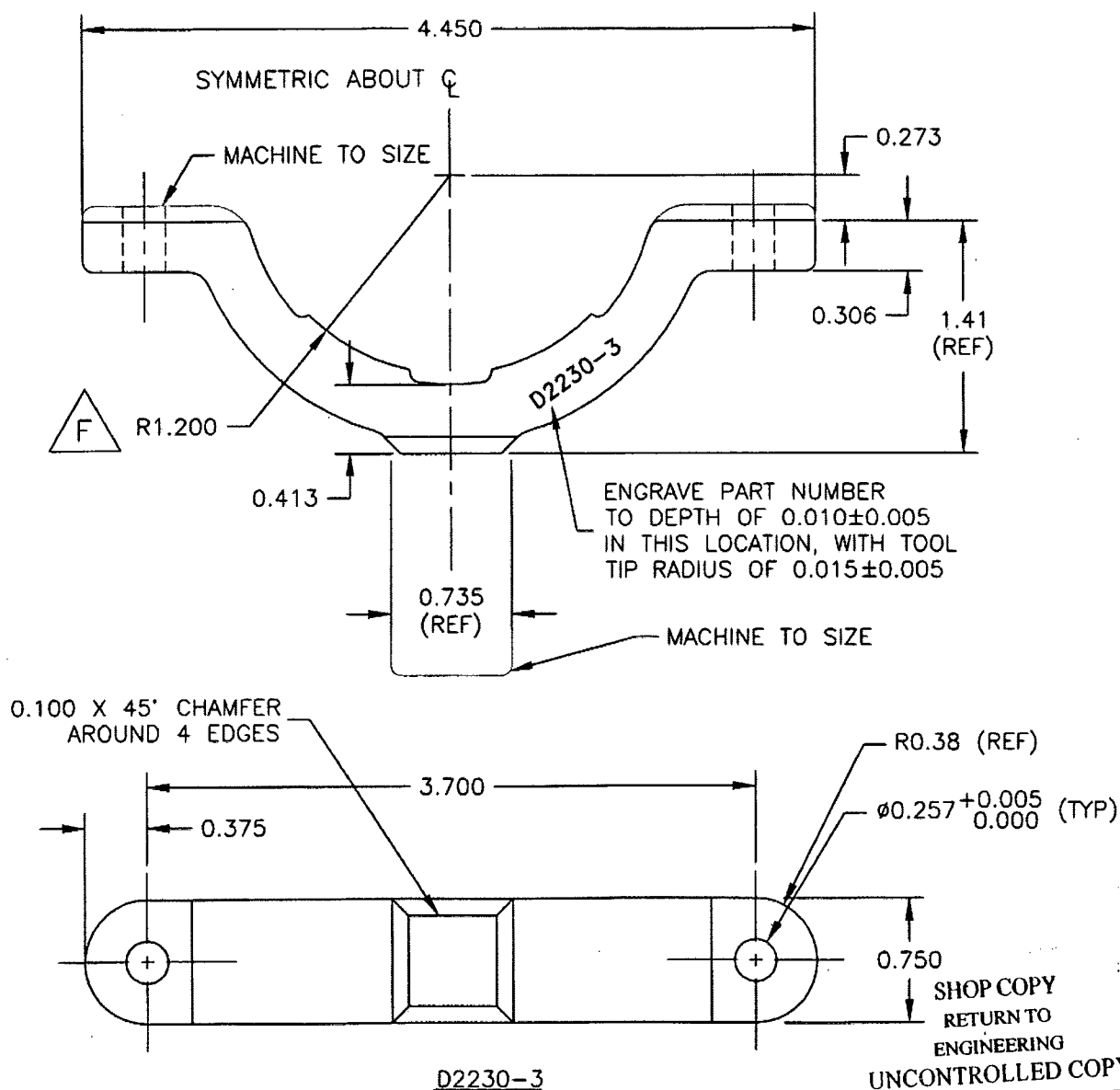
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 410727



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
49.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WITHOUT NOTICE  
WORK ORDER  
NO. 7042